

⑬



Europäisches Patentamt

European Patent Office

Office européen des brevets

⑪

Publication number:

**0 212 929
A2**

⑫

EUROPEAN PATENT APPLICATION

⑴ Application number: 86306173.5

⑵ Date of filing: 08.08.86

⑸ Int. Cl.: **A 61 F 2/30, A 61 C 8/00,
A 61 L 27/00**

⑶ Priority: 08.08.85 JP 175568/85
08.08.85 JP 175570/85

⑷ Date of publication of application: 04.03.87
Bulletin 87/10

⑸ Designated Contracting States: CH DE FR GB IT LI SE

⑹ Applicant: **SUMITOMO CHEMICAL COMPANY, LIMITED,**
15 Kitahama 5-chome Higashi-ku, Osaka-shi
Osaka 541 (JP)

⑺ Inventor: **Hama, Masaaki, 3810 NE, 75th St. Apt. No. 1,**
Seattle Washington 98115 (US)
Inventor: **Watanabe, Kellchirou, 2-11-7-508,**
Sone-Higashi-cho, Toyonaka-shi Osaka-fu (JP)
Inventor: **Ishimaru, Hiroshi, 2-3, Ikku-cho, Niihama-shi**
Ehime-ken (JP)

⑻ Representative: **Bizley, Richard Edward et al, BOULT,**
WADE & TENNANT 27 Fumival Street, London
EC4A 1PQ (GB)

⑿ Endosseous implants.

⑿ Endosseous implants are produced by thermally spraying a ceramic material onto the surface of a metallic core material having rough surface, i.e. a maximum surface roughness of 15 to 100 µm. The implants have the characteristics of both the metallic material and ceramic material and do not dissolve out harmful metal ions. The endosseous implants are useful for implantation in various bones including tooth roots and joints in living bodies.

EP 0 212 929 A2

ACTORUM AG

ENDOSSEOUS IMPLANTS

This invention relates to endosseous implants and to a method for producing them.

Implantation technology, which comprises the
5 insertion of artificial materials such as artificial organs, artificial blood vessels, artificial joints, artificial bones and artificial tooth roots into the body, has attracted much attention in recent years. It is said that trials of implantation go back to
10 ancient times. Particularly in the last ten years, a huge number of treatments by implantation have been performed on bones and tooth roots to afford good results in the remedy of defects or the recovery of functions thereof. However, there has not yet been
15 obtained an artificial bone or tooth root which satisfies the necessary requirements as a material for living bodies, i.e. affinity to living tissue, safety and excellent durability.

As metallic materials which have mainly been
20 used for preparation of artificial bones or tooth roots, cobalt-chromium alloys, stainless steel, titanium and tantalum are exemplified. On the other hand, as ceramic materials, alumina or materials comprising predominantly carbon have been recently
25 taken note of.

Although metallic materials are excellent in mechanical strength, particularly in impact strength, they lack affinity for living tissue. For example, when a metallic implant is used, metal ions are
30 dissolved out therefrom and are toxic to bone cells around the implant. Furthermore, bone-formation is obstructed, probably because of too large a thermal conductivity of the metallic implant. Among the metallic materials, titanium and tantalum are
35 particularly ~~superior in~~ a corrosion-resistance and hence have been employed as fixing plates for skulls

or fractured parts of bones and implants of jawbones since about 1940, but these are not necessarily satisfactory.

On the other hand, ceramic materials generally show a good affinity to bones, and tissues penetrate into fine pores of ceramic materials to afford a strong fixation, without adverse reaction between the ceramic material and the tissue. Besides, they are also excellent in durability, that is, they are resistant to corrosion or decomposition. On the other hand, they possess a poor impact strength.

There has been proposed an implant having the characteristics of both metallic materials and ceramic materials, i.e. an implant prepared by thermally spraying a ceramic material onto the surface of a metallic core material (cf. Japanese Patent First Publication Nos. 14095/1977, 82893/1977, 28997/1978 and 75209/1978). In these methods, however, a self-bonding type bonding agent is used in order to improve the adhesion of the ceramic coating layer. The bonding agent has the problem that it contains nickel, chromium, etc. which dissolve out in living tissue and have toxic effects on the body.

The present invention provides endosseous implants prepared by thermally spraying a ceramic material onto a metallic core material having a rough surface. More particularly, there is provided a method for producing an endosseous implant by thermally spraying a ceramic material onto a metallic core material having a maximum surface roughness of 15 to 100 μm .

In one embodiment, titanium hydride is thermally sprayed onto the surface of a metallic core material for making rough the surface thereof to a maximum surface roughness of 15 to 100 μm , and then a ceramic material is thermally sprayed thereon. In

another embodiment the metallic core material is roughened by etching with an acid to a maximum surface roughness of 15 to 100 μm , and then a ceramic material is thermally sprayed thereon.

5 The present invention will now be further described by way of example only with reference to the accompanying drawings, in which:

10 Figure 1 is a schematic view of an embodiment of the endosseous implant for the lower jawbone of a dog, wherein 1 represents the lower jawbone, 2 and 3 are natural teeth, 4 is an artificial tooth root and 5 is an artificial tooth crown attached on the artificial tooth root 4.

15 Figure 2 is a schematic view of an embodiment of the endosseous implant of blade type for the jawbone according to this invention, and (A) is a front view thereof and (B) is a side view thereof, wherein 6 represents a metallic implant (core material) and 7 is a ceramic layer containing
20 unopened pores which do not reach the metal surface.

 According to the present invention, as is shown in Figure 2, a ceramic coating is applied to the surface of a metallic implant core material so as to obtain an implant with good impact strength and
25 interacting with the surrounding bone tissues in a similar manner to ceramic materials.

 The metallic core materials used in this invention may be any suitable materials which have appropriate mechanical strength and are not harmful
30 to the body, including those materials which have usually been used as artificial materials for bones, joints and tooth roots which do not exhibit harmful effects on living tissue and possess an appropriate mechanical strength, for example, cobalt-chromium
35 alloys, stainless steels, titanium, titanium alloys, tantalum or zirconium. Among these materials,

preferred are titanium, titanium alloys, zirconium and tantalum in view of their excellent corrosion resistance. Most preferred are titanium and titanium alloys (e.g. 6 % Al-4 % V-Ti, etc.) in view of their
5 excellent processability and safety.

The ceramic materials used in this invention may be, for example, hydroxyapatite, calcium phosphate, aluminum oxide, zirconium oxide or titanium oxide, which may be used alone or in
10 combination of two or more thereof. In order to control the pores in the ceramic layer, porcelain may be applied by thermally spraying it together with the ceramic material or by baking it on the ceramic coating layer. For such a purpose, there can be used
15 porcelains such as Dentin and Enamel, for example. Among the ceramic materials, preferred are hydroxyapatite and aluminum oxide in view of their excellent affinity with living tissue. A combination of hydroxyapatite and aluminum oxide is particularly
20 suitable because it interacts most intimately with living tissue.

The endosseous implants of this invention can be produced in the following manner.

The metallic material is formed into the
25 desired shape, for example by conventional methods, such as cutting, casting, forging, punching, electro-arc machining, laser-processing, or powdered metal technique. The surface of the metallic core material thus formed is roughened to a specific maximum
30 surface roughness. The maximum surface roughness of the metallic core materials is in the range of 15 μm to 100 μm , the inventors having measured the roughness by the method described in JIS B-0601. When the maximum surface roughness is smaller than 15
35 μm , the thermally sprayed ceramic coating layer shows insufficient adhesion. On the other hand, when it is

larger than 100 μm , it is disadvantageously difficult
to form a thin uniform layer of the ceramic coating.
The most suitable maximum surface roughness is in the
range of 20 to 60 μm in view of the adhesion and
5 uniformity of the coating layer.

In order to roughen the surface of the metallic
core materials, various methods may be applied, for
example, mechanical methods such as grinding,
sandblasting, grit blasting, etc.; chemical etching,
10 e.g. treatment with an acid or alkali; electrolytic
etching; and forming a titanium layer with a rough
surface by thermally spraying titanium hydride
powder. Among these methods, preferred are blasting,
chemical etching, and forming a titanium layer with a
15 rough surface, because the ceramic material can
easily bite into the rough surface.

The chemical etching is usually carried out by
using mineral acids, for example sulfuric acid,
hydrochloric acid or hydrofluoric acid, which may be
20 used alone or in a combination of two or more
thereof. When blasting is combined with etching with
an acid, particularly when the metallic core material
is firstly subjected to blasting and then to etching
with an acid, the core material shows extremely
25 preferable adhesion of the coating layer. Besides,
when the metallic core materials are coated with
titanium having a rough surface by thermally spraying
titanium hydride powder, it is preferable to
previously subject the materials to the above
30 surface-roughening treatments, for example mechanical
treatment (e.g. grinding, sandblasting, grit
blasting), chemical etching with an acid or alkali or
electrolytic etching. The thermal spraying of
titanium hydride is preferably carried out by thermal
35 plasma spraying. The particle size of the titanium
hydride is not particularly limited, but is

preferably in the range of 10 to 100 μm . The titanium coating layer substantially does not release any harmful metal ion, unlike the self-bonding type bonding agent-containing metals which are easily dissolved out in living tissue.

In the thermal spraying of ceramic materials, any portion which is not coated with the ceramic material is previously masked by an appropriate means, for instance, application of a marking ink or an aluminum adhesive tape prior to the treatment for roughening the surface. The thermal spraying of the ceramic material is also preferably carried out by a thermal plasma spraying apparatus. Some portions of the endosseous implants, for instance, the ceramic coating layer in artificial joints, are required to be highly smooth. In such a case, a porcelain is coated onto the surface and the coated product is repeatedly calcined in a vacuum furnace.

In the endosseous implants of this invention, the thickness of the ceramic coating layer which optionally contains porcelain is not particularly limited, but is preferably in the range of 10 to 200 μm .

This invention is illustrated by the following Examples but should not be construed to be limited thereto. In the Examples, the surface roughness figures are as measured by the method of JIS B-0601.

Example 1

A core material for an endosseous implant is prepared from a titanium material (JIS, second class of material) by cutting and grinding the titanium material by electro arc machining.

The metallic core material for the implant is grit-blasted with a blast apparatus [a mammoth type ventiblast apparatus, manufactured by Metco Inc., England; blasting agent: Metcolite VF, manufactured

by Metco Inc. [pressure: 30 psi (205 kPa)]. The thus-blasted material has a maximum surface roughness of 10 μm .

The blasted core material is dipped in 30 % sulfuric acid solution at 50°C for 72 hours to effect etching. After the etching, the core material has a maximum surface roughness of 50 μm .

Under an argon-hydrogen-plasma jet flame (ARC electric current 500 Amp) generated by a plasma spray apparatus (6MM-630 type, manufactured by Metco Inc., equipped with an electric power supplier), a ground mixture of hydroxyapatite (particle size: 10 - 100 μm , 80 % by weight) and aluminum oxide (WA #120, manufactured by Nippon Kenmazai K.K., 20 % by weight) is thermally sprayed to form a coating layer having a thickness of about 150 μm on average. The thermally sprayed coating layer has excellent adhesion, and even when the product is subjected to bending processing at an angle of 160°, the coating layer is not peeled off.

The product obtained above was tested as follows:

The implant was embedded into the lower jawbone of a dog. After 3 months, it was observed by X-ray fluoroscopy. As a result, formation of dense bone around the implant was confirmed.

Example 2

A core material for an endosseous implant is prepared from a titanium material (JIS, second class of material) by cutting and grinding the titanium material by electro arc machining.

The metallic core material for the implant is grit-blasted with a blast apparatus [a mammoth type ventiblast apparatus, manufactured by Metco Inc., England; blasting agent: Metcolite VF, manufactured by Metco Inc.; pressure: 30 psi (205 kPa)]. The

thus-blasted material has a maximum surface roughness of 10 μm .

Under an argon-hydrogen-plasma jet flame (ARC electric current 500 Amp) generated by a plasma spray apparatus (6MM-630 type, manufactured by Metco Inc.,
5 equipped with an electric power supplier), titanium hydride powder (Powder No. XP-1157, manufactured by Metco Inc.) is thermally sprayed, as the first coating layer, onto the blasted core material to form
10 a first coating layer of about 50 μm in thickness over the whole surface thereof. As the second coating layer, a mixture of hydroxyapatite (particle size 10 - 100 μm , 80 % by weight) and aluminum oxide (WA #120, manufactured by Nippon Kenmazai K.K. 20 %
15 by weight) is thermally sprayed to form a coating layer having a thickness of about 150 μm on average. The thermally sprayed coating layer has excellent adhesion, and even when the product is subjected to a bending process at an angle of 160° , the coating
20 layer is not peeled off.

The product obtained above was tested as follows:

The implant was embedded into the lower jawbone of a dog. After 3 months, it was observed by X-ray
25 fluoroscopy. As a result, there was confirmed formation of dense bone around the implant.

Reference Example

A core material for an endosseous implant is prepared by treating the same titanium material in
30 the same manner as described in Example 1. The core material is likewise subjected to grit blasting, but is not subjected to etching. The material has a maximum surface roughness of 10 μm which is about 1/5 of that of the core material before thermal spraying
35 in Example 1.

The blasted core material is thermally sprayed

with a mixture of hydroxyapatite and aluminum oxide in the same manner as in Example 1 to give a coating layer having a thickness of about 150 μm on average. The resulting product has significantly inferior
5 adhesion of the coating layer and the coating layer is easily peeled off even by a light impact. Thus, this product cannot be used as an endosseous implant.

It will be appreciated from the foregoing that in accordance with the invention there may be
10 provided endosseous implants comprising a metallic core whose surface is roughened to a maximum roughness of 15 to 100 μm and a ceramic material directly bonded to the metallic core without a bonding agent. Preferably, roughening is provided by
15 a titanium layer on the metallic core and, optionally, the surface of the metallic core below the titanium layer is roughened. This roughening of the surface of the metallic core which acts as a substrate for the titanium layer may be achieved by
20 blasting or chemical etching or both.

It will also be seen from the foregoing that we have provided an endosseous implant which has good impact strength and the affinity for living tissue of ceramics but need not release toxic metal ions into
25 the body.

30

35

CLAIMS:

1. A method for producing an endosseous
5 implant, comprising roughening the surface of a
metallic core material to a maximum surface roughness
of 15 to 100 μm and then thermally spraying ceramic
material onto the roughened surface of the metallic
core material.
10
2. A method according to claim 1, wherein the
surface of the metallic core material is roughened by
subjecting the core material to etching with an acid.
- 15 3. A method according to claim 2, wherein the
surface of the metallic core material is subjected to
blasting before the etching.
4. A method according to claim 1, wherein the
20 surface of the metallic core material is roughened by
thermally spraying titanium hydride onto the surface
of the core material.
5. A method according to claim 4, wherein the
25 surface of the metallic core material is subjected to
blasting or etching with an acid or both before being
thermally sprayed with titanium hydride.
6. A method according to any one of the
30 preceding claims, wherein the metallic core material
has a maximum surface roughness of 20 to 60 μm .
7. A method according to any one of the
preceding claims, wherein the ceramic material for
35 thermal spray coating comprises hydroxyapatite.

8. A method according to any one of claims 1 to 6, wherein the ceramic material for thermal spray coating comprises a mixture of hydroxyapatite and aluminum oxide.

5

9. An endosseous implant comprising a metallic core whose surface is roughened to a maximum surface roughness of 15 to 100 μm and a ceramic material thermally sprayed onto the roughened surface.

10

10. An endosseous implant according to claim 9, wherein the roughening of the metallic core is provided by a titanium layer thereon.

15

20

25

30

35

1/1

Figure 1

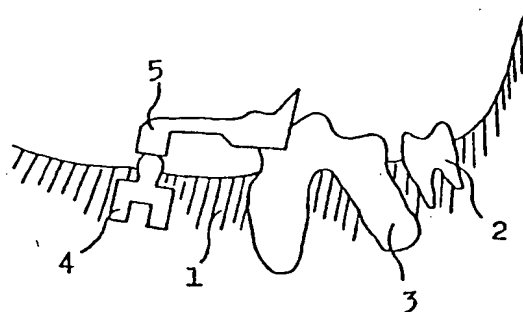
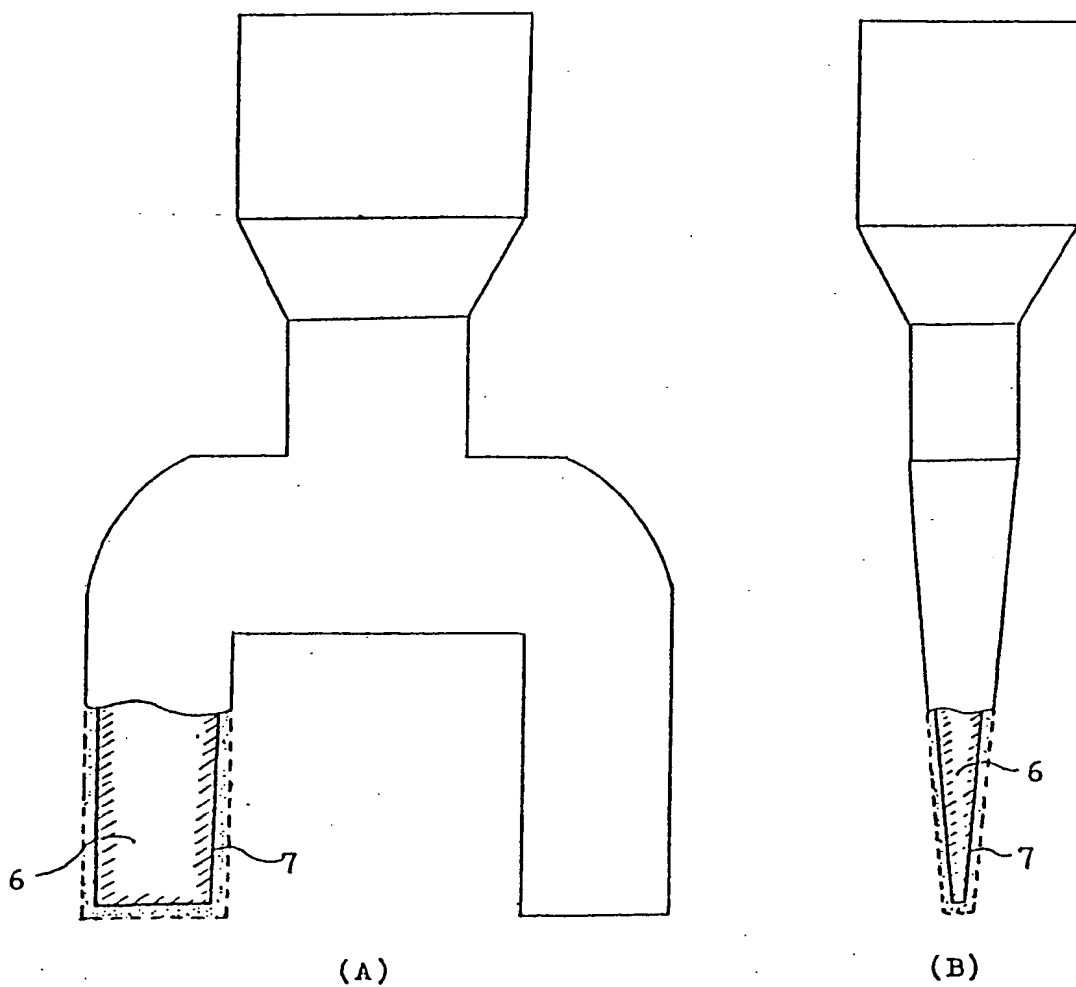


Figure 2





Europäisches Patentamt
European Patent Office
Office européen des brevets

(19)

(11) Publication number:

0 212 929
A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 86306173.5

(51) Int. Cl.³: A 61 F 2/30
A 61 C 8/00, A 61 L 27/00

(22) Date of filing: 08.08.86

(30) Priority: 08.08.85 JP 175568/85
08.08.85 JP 175570/85

(43) Date of publication of application:
04.03.87 Bulletin 87/10

(88) Date of deferred publication of search report: 06.04.88

(64) Designated Contracting States:
CH DE FR GB IT LI SE

(71) Applicant: SUMITOMO CHEMICAL COMPANY, LIMITED
15 Kitahama 5-chome Higashi-ku
Osaka-shi Osaka 541(JP)

(72) Inventor: Hama, Masaaki
3810 NE, 75th St. Apt. No. 1
Seattle Washington 98115(US)

(72) Inventor: Watanabe, Keiichirou
2-11-7-508, Sone-Higashi-cho
Toyonaka-shi Osaka-fu(JP)

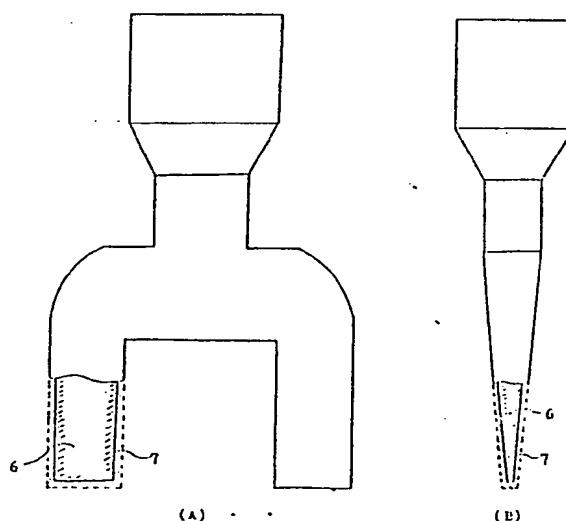
(72) Inventor: Ishimaru, Hiroshi
2-3, Ikku-cho
Niihama-shi Ehime-ken(JP)

(74) Representative: Bizley, Richard Edward et al,
BOULT, WADE & TENNANT 27 Farnival Street
London EC4A 1PQ(GB)

(54) Endosseous implants.

(57) Endosseous implants are produced by thermally spraying a ceramic material onto the surface of a metallic core material having rough surface, i.e. a maximum surface roughness of 15 to 100 μm . The implants have the characteristics of both the metallic material and ceramic material and do not dissolve out harmful metal ions. The endosseous implants are useful for implantation in various bones including tooth roots and joints in living bodies.

Figure 2



Croydon Printing Company Ltd.

EP 0 212 929 A3

European Patent
Office

EUROPEAN SEARCH REPORT

0212929

Application Number

EP 86 30 6173

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
A	DE-A-2 313 678 (BECKER et al.) * claims 1,4,5 *	1,9	A 61 F 2/30 A 61 C 8/00 A 61 L 27/00
A	FR-A-2 374 020 (ONTARIO RESEARCH FOUNDATION) * claims 1,6,8,9 *	1,4,9	
A	FR-A-2 318 617 (SUMITOMO CHEMICAL CO., LTD.) * claims 8,9 * & JP - A - 52 014 095 (Cat. D,A)	1	
A	FR-A-2 336 913 (SUMITOMO CHEMICAL CO., LTD.) * claims 16,22 * & JP - A - 52 082 893; & JP - A - 53 028 997 (Cat. D,A)	1	
A	FR-A-2 374 019 (SUMITOMO CHEMICAL CO., LTD.) * claims 5,6 * & JP - A - 53 075 209 (Cat. D,A)	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			A 61 C 8/00 A 61 F 2/00 A 61 L 27/00
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 21-12-1987	Examiner KANAL P K
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			

EPO FORM 1503 03.82 (P0401)